

Work Order ID 63374

Thursday, October 28, 2010 10:19:40 AM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/28/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 10/10/28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

N/A C2 10/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Set Up/
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Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

DP

10-11-3

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

BE 10/11/03

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch:

M115778/M111385

BE 10/11/04

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D3274

BE 10/11/04

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1			BB 10/11/09
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							8101109
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							8101109

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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☐ 1116040 ☐

Sikaflex expire date: ☐ 11-9-30 ☐

Start: ☐ 10-11-15 ☐ Time: ☐ 2 PM ☐

Finish: ☐ 10/11/16 ☐ Time: ☐ 3:55 AM

(Adhere for 12 hours)

160



QC

Quality Control

ac5

QC Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

10/11/16

10/11/10

10-11-15

70

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Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.								
	2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr								
	3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES								
	4- Countersink crossbolt spacer holes as per Dwg D3274								
	5- prepare for welding								
180 	QC6- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							

BE 10/11/10

BB

10/11/10

L = 24.5"

h = 2.9125"

10/11/10



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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R ☐ Aluminum Rod

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

200



QC

Quality Control

~~QC~~ - Inspect part completeness to step on W/O

0.00

Memo

0.00

Sioluliz

HC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date:	11/4/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC Quality Control	Memo	0.00				70			
220 	Pressure Wash per QSI005 4.3	0.00							
HandFinish Hand Finishing	Memo ✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch	0.00				1	0		
230 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo START TIME: 8:00 OVEN TEMPERATURE: 320° FINISH TIME: 8:30	0.00							1 BL 10-11-18

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270

0.00



HandFinish

Hand Finishing

HAND FINISHING RESOURCE #1

Memo

0.00

✓ 1-Install wearpads & gaskets as per Dwg D3274.

✓ 2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☒ M115114 ☐

Sikaflex expire date: ☐ 11/06

✓ 3-Inspect for foreign objects as per QSI 024

✓ 4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: 101A

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

✓ A/R ☐ Sikaflex-291 ☒ M115114 ☐

Sikaflex expire date: ☐ 11/06

280



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 columns

(40)

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Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

PDP 62709

0.00

Packaging

Cecilia 10 11

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/12/13

ME

10-12-10

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Picklist Print

Thursday, October 28, 2010 10:19:44 AM

Page 1

Work Order ID: 63374

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/4/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-1-190

Manufactured No

110

Each

63.0000

1

1



Extrusion Round 3" 206

Location

Loc Qty

Loc Code

LG

63

47575

15

59874

48

DP 10-11-3

D3285-1

Manufactured No

110

Each

141.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG

141

52511

74

52647

67

BE 10-11-04

D3282-041

Manufactured No

150

Each

0.0000

1

1



Float Web (206L/407)

B 63390

DP 10-11-15

W/O:		WORK ORDER CHANGES					
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Required Date: 11/4/2010

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

107.0000

12

12



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

107

58545

2

60652

4

61496

13

62889

88

B 63359

12 BE 10/11/10

D3275-1

Manufactured No

190

Each

216.0000

12

12



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

216

53453

8

61646

102

62399

106

12 BE 10/11/10

CR3212-4-03

Purchased No

250

Each

1,874.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

1874

111359

5

112314

2

114436

448

114450

71

114859

1348

x2

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Shop Packet Print

Page 2

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Start Date: 10/28/2010

Required Date: 11/4/2010

Start Qty: 1.00

Required Qty: 1.00

D3415-041 Manufactured No

250 Each

52.0000

1



Nut Plate



1
10/11/18

Location

Loc Qty

Loc Code

ST056

52

33842

52

x2

CCR264SS3-3 Purchased No

250 Each

416.0000

2



Cherry Rivet



2
10/11/18

Location

Loc Qty

Loc Code

ST311

416

112314

4

113539

44

113973

368

x2

ALS4-1032-130 Purchased No

250 Each

2,653.000

78



Insert



78
10/11/18

Location

Loc Qty

Loc Code

PKG11

886

114723

886

ST282

1728

110511

10

115911

1718

x78

ST381

39

114654

39

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Start Date: 10/28/2010

Required Date: 11/4/2010

Start Qty: 1.00

Required Qty: 1.00

D3536-15

Manufactured No

270

Each

18.0000

1

1



Gasket



yl 10/11/18

Location

Loc Qty

Loc Code

FP

6

B63568

yl

56055

1

60875

5

FP11

12

59238

1

62459

11

D3536-23

Manufactured No

270

Each

3.0000

1

1



Gasket



yl 10/11/18

Location

Loc Qty

Loc Code

FP011

3

B63238

yl

61237

3

D3536-35

Manufactured No

270

Each

16.0000

1

1



Gasket



yl 10/11/18

Location

Loc Qty

Loc Code

FP012

16

B63579

yl

58683

1

61692

3

62462

12

D3536-39

Manufactured No

270

Each

12.0000

1

1



Gasket



yl 10/11/18

Location

Loc Qty

Loc Code

FP12

12

B63578

yl

58215

1

58571

11

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Work Order ID: 63374

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/4/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-15 Manufactured No 270 Each 22.0000 1 1
Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP18	22	
61241	6	
62241	3	
62707	13	

D3535-35 Manufactured No 270 Each 26.0000 1 1
Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP018	26	
60865	6	
62461	12	
62969	8	

D3535-39 Manufactured No 270 Each 27.0000 1 1
Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP18	27	
60233	16	
62945	11	

Thursday, October 28, 2010 10:19:45 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:19:45 AM

Page 6

Work Order ID: 63374

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/4/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-23

Manufactured No

270

Each

28.0000

1

1



Wearshoe



10/11/18

Location

Loc Qty

Loc Code

FP
61830
FP021
60231
62706

7
6
21
8
13

Y1

D3537-3

Manufactured No

270

Each

40.0000

1

1



Wearpad



10/11/18

Location

Loc Qty

Loc Code

FP17
60866
61674
62705

40
3
17
20

Y1

D3537-1

Manufactured No

270

Each

66.0000

9

9



Wearpad



10/11/18

Location

Loc Qty

Loc Code

FP
55465
FP017
61986
62209
FP17
57713
60491

1
1
59
15
44
6
3
3

1362928

Y9

Thursday, October 28, 2010 10:19:45 AM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:19:45 AM

Page 7

Work Order ID: 63374

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/4/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

270 Each 29.0000 80 80



washer



10/11/18

Location

Loc Qty

Loc Code

ST245

29

107534

29

M115832

x80

AN960C416 NAS1149C0463 Purchased No

270 Each 30.0000 1 1



washer

M115358



10/11/18

Location

Loc Qty

Loc Code

ST346

30

100993

30

D3672-1 Manufactured No

270 Each 847.0000 2 2



Phenolic Washer



10/11/18

Location

Loc Qty

Loc Code

ST077

847

42329

150

52505

697

y2

Thursday, October 28, 2010 10:19:45 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:19:45 AM

Page 8

Work Order ID: 63374

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/4/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

2,233.000

80

80



BOLT



10/11/18

Location

Loc Qty

Loc Code

ST303

3

115438

3

ST350

2230

114108

14

114416

12

114523

2

115300

202

115589

1000

115936

1000

V80

AN4C5A

Purchased

No

270

Each

481.0000

1

1



BOLT



Location

Loc Qty

Loc Code

ST346

481

110552

4

112243

477

10-11-18

D2646

Manufactured

No

270

Each

45.0000

1

1



Aft Cap



10/11/18

Location

Loc Qty

Loc Code

FP-4

35

57332

35

fp5

6

62652

6

FP6

4

52663

4

V1

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:19:45 AM

Page 9

Work Order ID: 63374

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/4/2010

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

270

Each

23.0000

1

1



Handwritten: 10/11/18

Ring

Location

Loc Qty

Loc Code

ST473

23

51586

1

53446

7

61322

15

Handwritten: Y1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED

07.02.12

DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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SHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63874

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

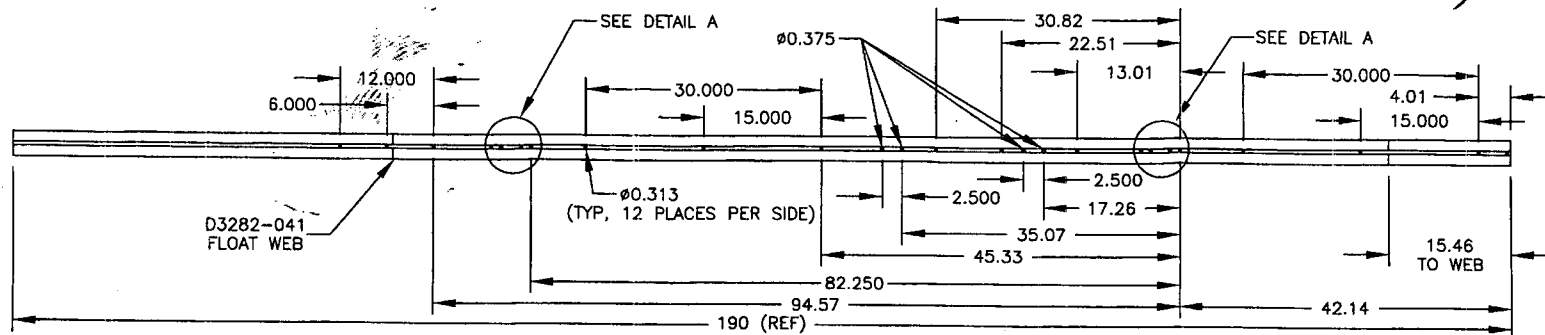
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

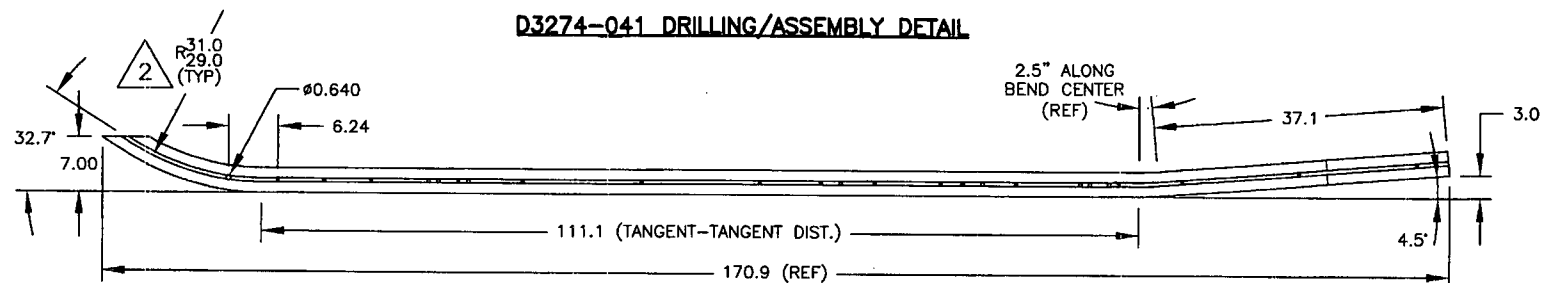
NOTE: Date & initial all entries

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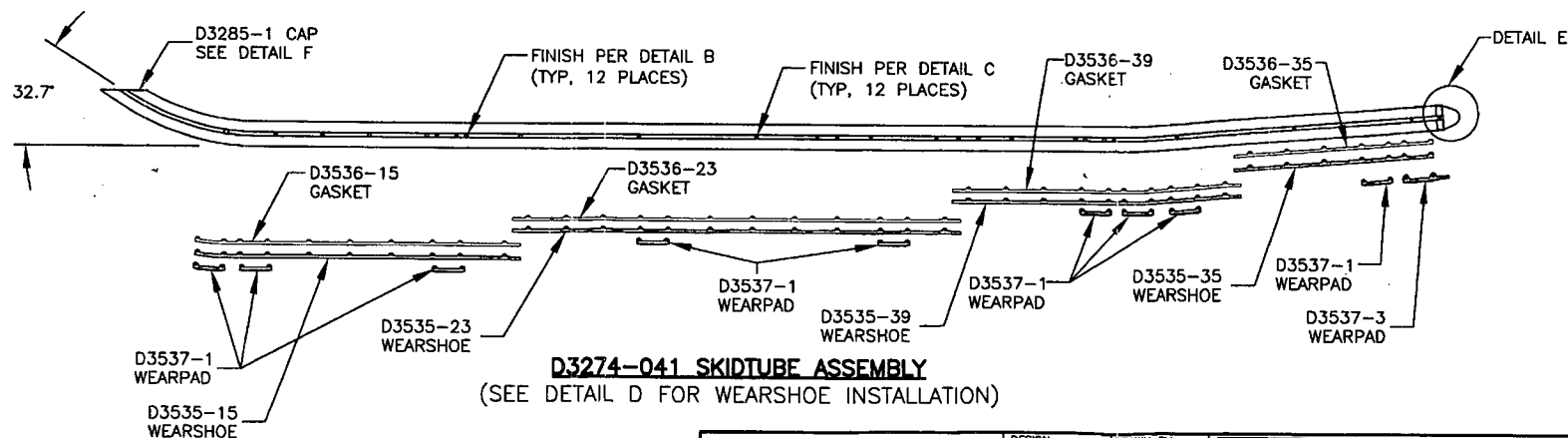
W/O 43374



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DESIGN	CP	DRAWN BY	PH	DART	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	PORT WADLOCK, WA	
DATE	06.12.19	DRAWING NO.	D3274	REV. D	SHEET 2 OF 4
		TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

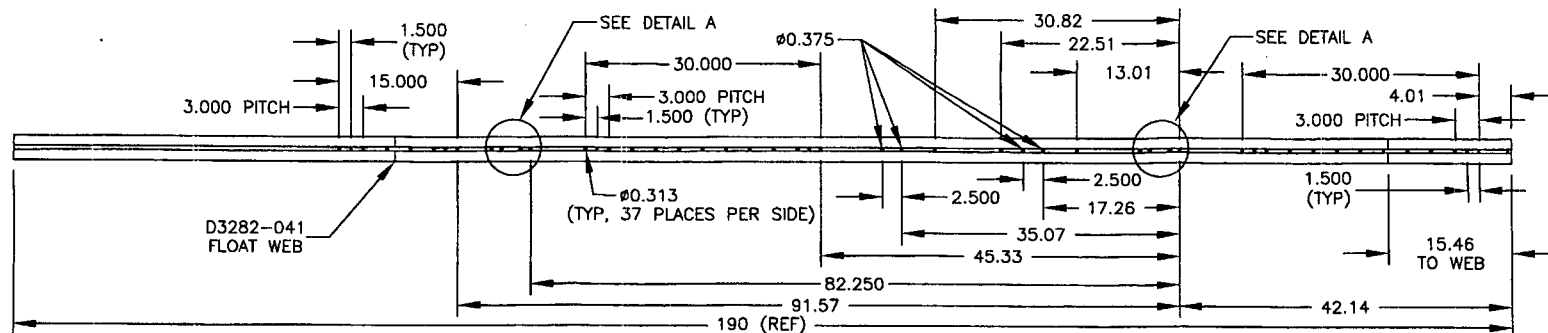
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

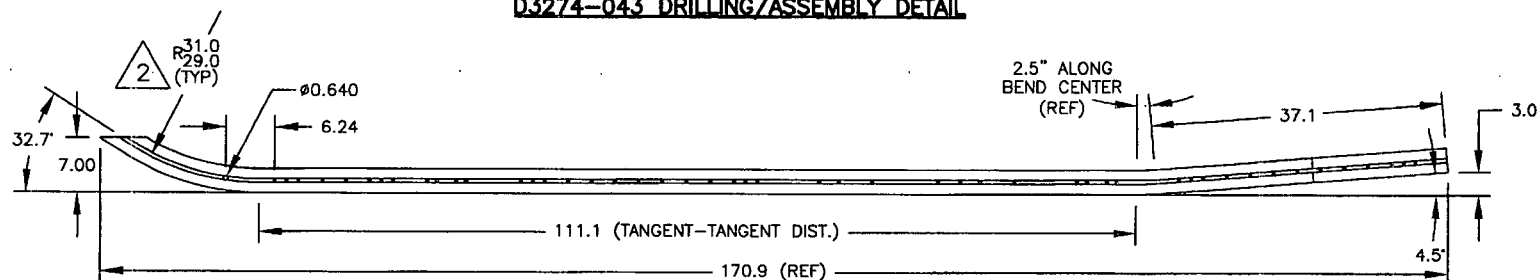
NOTE: Date & initial all entries

DEO ATTACHED

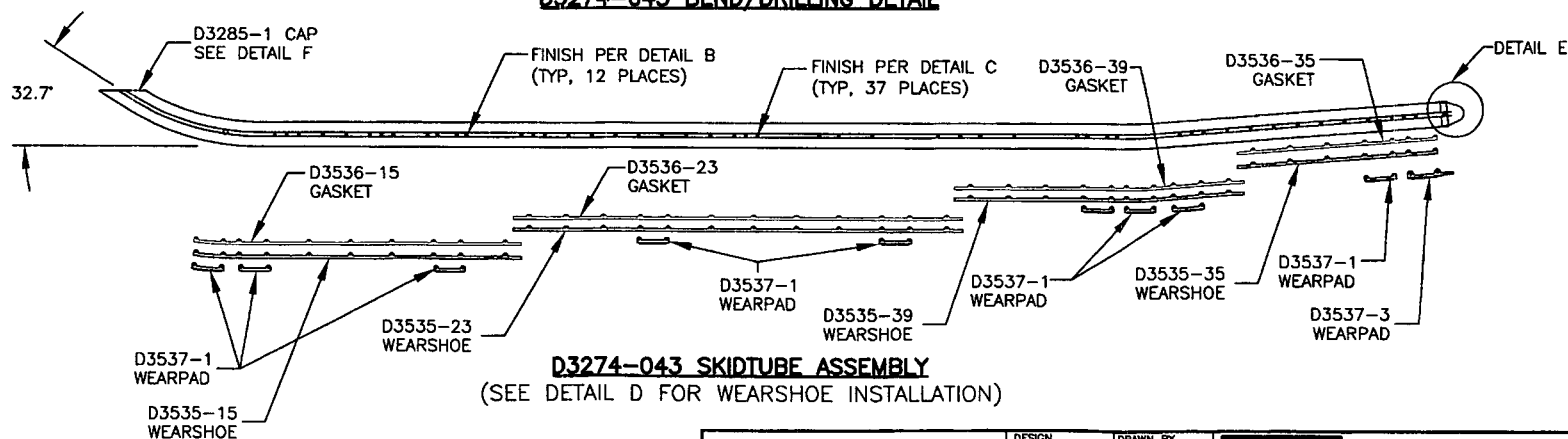
46 63379



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DESIGN	CP	DRAWN BY	PH	DART	DART AEROSPACE USA, INC.
CHECKED	#	APPROVED	#	DRAWING NO.	D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D	SHEET 3 OF 4
				SCALE	1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

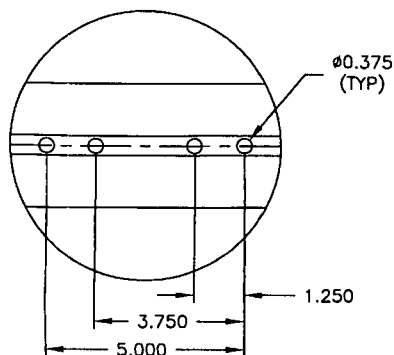
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

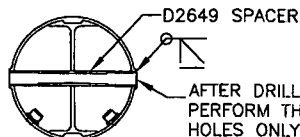
NOTE: Date & initial all entries

u/o'G3374.

DETAIL A: DRILL DETAIL

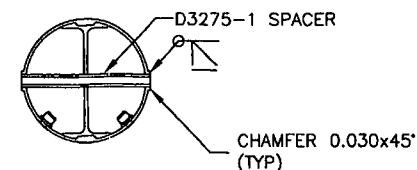


DETAIL B FOR 0.375 HOLES ONLY

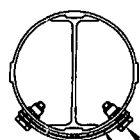


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



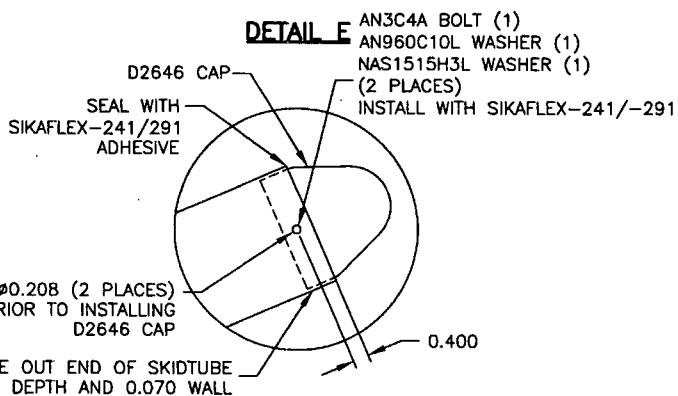
DETAIL D



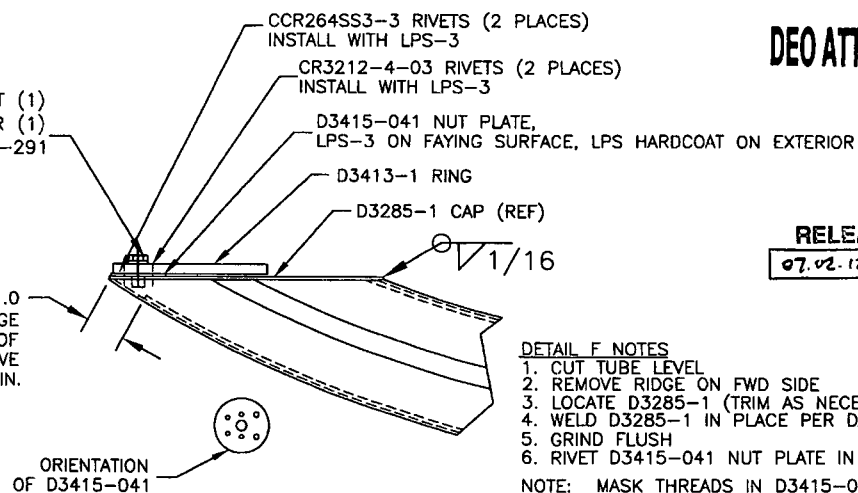
- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(7B PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



DETAIL F: END FINISHING DETAIL



- DETAIL F NOTES
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DEO ATTACHED

RELEASED
07.02.12

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DART AEROSPACE USA, INC.

DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, VA
CHECKED	H	APPROVED	H	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 4 OF 4 SCALE 1:3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>A</i>	MFG. APPR. <i>A</i>	APPROVED <i>WAP</i>	DE APPR. <i>H</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

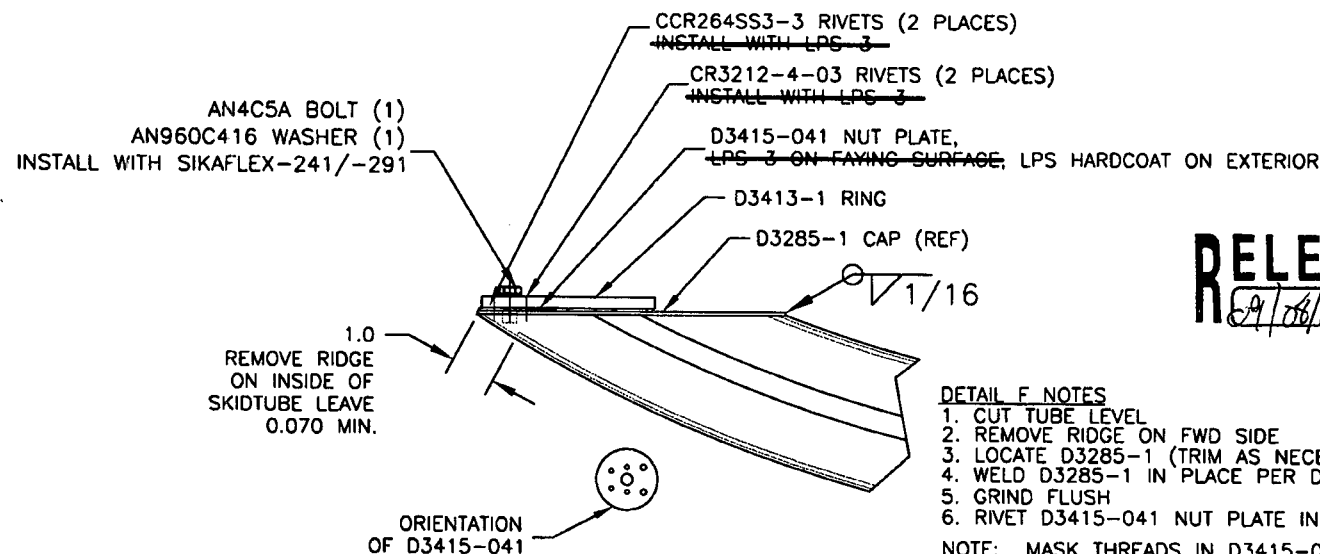
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

w/o 43374

DETAIL F: END FINISHING DETAIL



RELEASED
09/06/23

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 241

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 622500
Part number: D206-642-541
Description: 206 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P.D.D. Date of Test Coupon 10.09.20
Welder Barclay Elliott Date of Test Coupon 10.09.20

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.